

Date: Tuesday, 4/17/2007 11:04:54 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 31829		
Estimate Number	: 11593		
P.O. Number	: <u>NIA</u>	Part Number	: D2912
This Issue	: 4/17/2007	S.O. No.	: <u>NIA</u>
Prsht Rev.	: NC	Drawing Number	: D2912 REV A
First Issue	: <u>NIA</u>	Project Number	: N/A
Previous Run	: <u>NIA</u>	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	: <u>NIA</u>
Written By	:	Due Date	: 4/24/2007
Checked & Approved By	:	Qty:	20 Um: Each
Comment	: Est B 02.01.12 Re-format; Incorporated D2911 and D2912 K J Est Rev:C Now on Waterjet 07-01-23 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S090	6061-T6 .090 Sheet
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Comment: Qty.: 0.1030 sf(s)/Unit Total : 2.0601 sf(s)
 6061-T6 .090 Sheet
 Material: Sheet 6061-T6 x 0.090" thick
 (M6061T6S.090)
 Batch: M19295

ml 07 04 18

(20)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2912
 Dwg Rev: A
 Prog Rev: A

ml 07 04 18

(20)

2-Deburr if necessary

8B

07/04/19

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



ml 07 04 18

(20)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07-04-18
 counted

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PP Date: 07/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:04:54 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 31829

Part Number: D2912

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form on CNC brake as per Dwg D2910, D2911, D2912 and QSI 034 4.1

SB 07/04/18 20

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

For 07/04/18 20

(P10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/15/08 (20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

07/05/08

Job Completion



07/05/08

(20X)

6.1 Acid etch : Abolone Per QSI 005.

M-h 07/05/07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
0704-20	6-1	Acid etch & Hlocline per Dwg. Perm change				<i>[Signature]</i> 0704-20	<i>[Signature]</i> 0704-20	

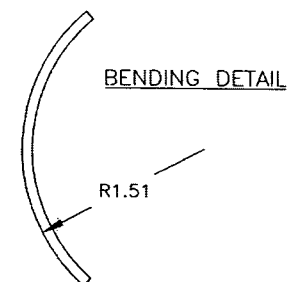
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

99.09.28



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 31829



A	99.09.07	NEW ISSUE	
DESIGN CP	DRAWN BY RF	DART DART AEROSPACE USA, INC. BELLINGHAM, WA	REV. A
CHECKED CP	APPROVED RH	DRAWING NO. D2912	SHEET 1 OF 1
DATE 99.09.07		TITLE DOUBLER	SCALE 1:1

DART AEROSPACE LTD		Work Order: 318 29
Description: Doubler		Part Number: 02912
Inspection Dwg: 02912	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.91	+/-0.030	5.915	✓		vern	
B	1.183	+/-0.010	1.186	✓		vern	
C	1.772	+/-0.010	1.772	✓		vern	
D	3.543	+/-0.010	3.542	✓		vern	
E	2.37	+/-0.030	2.372	✓		vern	
F							
G							
H							
I							
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: ml ml	Audited by: [Signature]	Prototype Approval:	N/A
Date: 070418	Date: 070418	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	[Signature]